

Work Order ID 132494

132494

Page 1

November 10, 2015 2:19:35 PM

Item ID: D206-817-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Screw-In Windshield Modification
 Start Date: 5/25/2015 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 6/1/2015 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: SW Date: 20151110 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
DSI9659	A	DAS 6 9-89
DSI9687	A	
IIN-D206-817	D	

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D206-817-011 CHG006

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging

MLJ 15-11-24 (3)

3 DAS 38 9-89 15-11-24

3 DAS 6 9-89 DAS 28 9-89 NOV 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 132494***132494***

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Item ID: D206-817-011

Accept

N19000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Screw-In Windshield Modification

Start Date: 5/25/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/1/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-89

15-11-24

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-817-011
Location: FG033

3x

DAS
28
9-89

NOV 24 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MLJ

15-11-27

MLJ 15-11-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
				OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 132494

132494

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/25/2015

Required Date: 6/1/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687
DD VERF:JLM IPP REV:G 15.01.06 now @ chg006/ecn14-547 DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-1		Manufactured	No			110	Each	13.0000	1	3			DAS 6 9-89
D4541-1									**				DAS 28 9-89
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST626				13					
				118995	118			1					
				127095				12					
D4541-2		Manufactured	No			110	Each	12.0000	1	3			DAS 6 9-89
D4541-2									**				DAS 28 9-89
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST626				12					
				127096				12					
D4542-1		Manufactured	No			110	Each	5.0000	1	3			DAS 6 9-89
D4542-1									**				DAS 28 9-89
Retainer, Inner, LH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST628				5					
				122802	122			1					
				129997				4					

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Work Order ID: 132494

132494

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/25/2015

Required Date: 6/1/2015

Start Qty: 3.00

Required Qty: 3.00

D4541-6	DAS 38 9-89	Manufactured	No	110	Each	9.0000	1	3	DAS 6 9-89
D4541-6							**		
Bracket,RH									

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Work Order ID: 132494

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

132494

D206-817-011

Start Date: 5/25/2015

Required Date: 6/1/2015

Start Qty: 3.00

Required Qty: 3.00

D4544-1 Manufactured No

D4544-1

Retainer, Center

DAS
33
9-89

110 Each 10.0000 1 3

★★

DAS
6
9-89
DAS
28
9-89

Location Loc Qty Loc Code

ST629 10

123675 1

130522 9

110 Each 9.0000 1 3

★★

DAS
6
9-89
DAS
28
9-89

Location Loc Qty Loc Code

ST633 9

126482 1

129860 3

133135 4

133841 1

D4594-1 Manufactured No

D4594-1

Plate

DAS
38
9-89

D4595-150-13 Manufactured No

D4595-150-13

Sealant Tape (13' Long)

DAS
38
9-89

110 Each 355.0000 2 6

★★

DAS
6
9-89
DAS
28
9-89

Location Loc Qty Loc Code

MF 336

119766 336

pk16 19

B120054 19

AN525-10R7 Purchased No

AN525-10R7

SCREW

DAS
38
9-89

110 Each 358.0000 95 285

★★

DAS
6
9-89
DAS
28
9-89

Location Loc Qty Loc Code

ST329 358

m131697 358

NOV 10 2015

285

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Shop Packet Print

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Work Order ID: 132494

132494

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/25/2015

Required Date: 6/1/2015

Start Qty: 3.00

Required Qty: 3.00

MS20426AD3-4

Purchased

No

110

Each

3,717.000

190

570

MS20426AD3-4

DAS
33
9-89

**

DAS
6
9-89
DAS
28
9-89

RIVET

Location

Loc Qty

Loc Code

GA

3149

m131697

3149

ST312

568

125578

7

m125578

181

m127432

380

~~188~~
382

MS21059L08

Purchased

No

110

Each

244.0000

43

129

MS21059L08

DAS
38
9-89

**

DAS
6
9-89

Nut

Location

Loc Qty

Loc Code

CCK007

200

m131697

200

ST301

40

125654

40

ST303

4

m131624

4

91
38

MS21059L3K

Purchased

No

110

Each

774.0000

93

279

MS21059L3K

DAS
38
9-89

**

DAS
6
9-89
DAS
28
9-89

Nutplate

Location

Loc Qty

Loc Code

CCK007

500

m131677

500

GA

160

m127635

160

ST300

114

m131618

114

148 163x

116x

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Work Order ID: 132494

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

132494

D206-817-011

Start Date: 5/25/2015

Required Date: 6/1/2015

Start Qty: 3.00

Required Qty: 3.00

MS21061L08

Purchased

No

110

Each

88.0000

10

30

MS21061L08

Nutplate

DAS
38
9-89

**

DAS
28
6
9-89

Location

Loc Qty

Loc Code

ST300

88

m131697

88

30

MS21075L08

Purchased

No

110

Each

235.0000

1

3

MS21075L08

ANCHOR NUT

DAS
38
9-89

**

DAS
28
6
9-89

Location

Loc Qty

Loc Code

ST298

126

103053

55

M132035

71

3

ST300

109

M128635

109

MS27039-08-10

Purchased

No

110

Each

751.0000

42

126

MS27039-08-10

Screw

DAS
38
9-89

**

DAS
28
6
9-89

Location

Loc Qty

Loc Code

ST281

751

m128799

751

126

NAS1149DN832J

Purchased

No

110

Each

1,503.000

42

126

NAS1149DN832J

Washer

DAS
38
9-89

**

DAS
28
6
9-89
NOV 10 2015

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST270

1419

M129541

153

M131697

1266

126

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Shop Packet Print

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Work Order ID: 132494

132494

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 5/25/2015

Required Date: 6/1/2015

Start Qty: 3.00

Required Qty: 3.00

MS21061L3K

Purchased

No

110

Each

52.0000

2

6

MS21061L3K

DAS

38

9-89

NUT PLATE

DAS

28

DAS

6

9-89

9-89

Location

Loc Qty

Loc Code

GA

52

125268

2

m131467

50

2
4

NOV 10 2015

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 13.06.20
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	08	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	08	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	08		
CHECKED	14	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	08	TITLE	SCALE
DE APPR.	08	SEALANT TAPE	NTS
DATE	13.06.20	COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOWN BY
R. J. J. J.
UNCONTROLLED
132494 MLS
150571

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2
REF. TCCA STC SH12-3
REF. FAA STC SR03091NY
REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
DATE	14.03.18	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 INSTALLATION

IF INSTALLING A D206-817-011 KIT AT CHG 005 OR LATER, STEP 3.3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV D IS MODIFIED IS FOLLOWS:

3.3 Install Dart inner retainers. It is acceptable to hand form retainers as required to allow fit. Retainers should be located so that they are approximately flush with the aircraft skin. Locate retainers and transfer drill Ø0.128" from aircraft frame. Locate as follows, using Figure 3-2 as reference:

- Locate D4541-1/-2 Brackets along the bottom window frame flush against the door pillars. The Bracket should be oriented with the hole pattern for the MS21061L3K nutplate (the non-symmetric nutplate, ref) near the door post. See Figure 3-3 for reference.
- Locate D4541-3/-4 Brackets on the door pillars, above the -1/2 Brackets. See Figure 3-3.
- Locate D4541-5/-6 Brackets above the -3/-4 retainers. See Figure 3-4.
- Locate D4541-7/-8 Brackets along the top edge, with one side aligned with the center column. See Figure 3-4.
- Relocate the 206-031-112-039 (or equiv.) clip removed at step 3.2(g) per Figure 3-3.

Install brackets wet with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 sealant between retainers and a/c frame. Fasten D4541-1/-2 Lower Inner Brackets with CR3214-4 (or NAS9301B or M7885/2) rivets and NAS1149DN432J (or 140-001-1 or AN960JD4 or equiv.) washers. Fasten D4541-X Brackets with MS20600AD4 rivets. Reinstall clip (206-031-112-039 or equiv.) with CR3213-4 rivets. See Figure 3-3 for reference.

*Note: Due to variations in airframes the D4541-X Brackets have been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

3.4 Locate D4542-X Retainers onto the D4541-X Brackets as follows, see Figures 3-3 & 3-4 for reference:

- Locate D4542-1 Retainers onto the D4541-1/-2 Brackets
- Locate D4542-3 Retainers onto the D4541-3/-4 Brackets
- Locate D4542-5 Retainers onto the D4541-5/-6 Brackets
- Locate D4542-7 Retainers onto the D4541-7/-8 Brackets

Hand form D4541-X Brackets and/or D4542-X as required to fit profile of windshield. Locate and transfer drill rivet holes to D4542-X Retainers and open to Ø0.098. Locate and transfer drill screw holes and open to Ø0.250". Dimple the Ø0.098 holes Ø0.180 x 100° and install MS21059L3K nutplates with MS20426AD3-4 rivets.

*Note: Due to variations in airframes the D4542-5 Retainer has been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

FIGURES 3-2 & 3-3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D ARE MODIFIED AS SHOWN ON SHEETS 3 AND 4 OF THIS SERVICE INSTRUCTION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	14.03.18
CERT. NO.:	SH12-3
ISSUE NO.:	1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER KIT	NTS
DATE	14.03.18	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

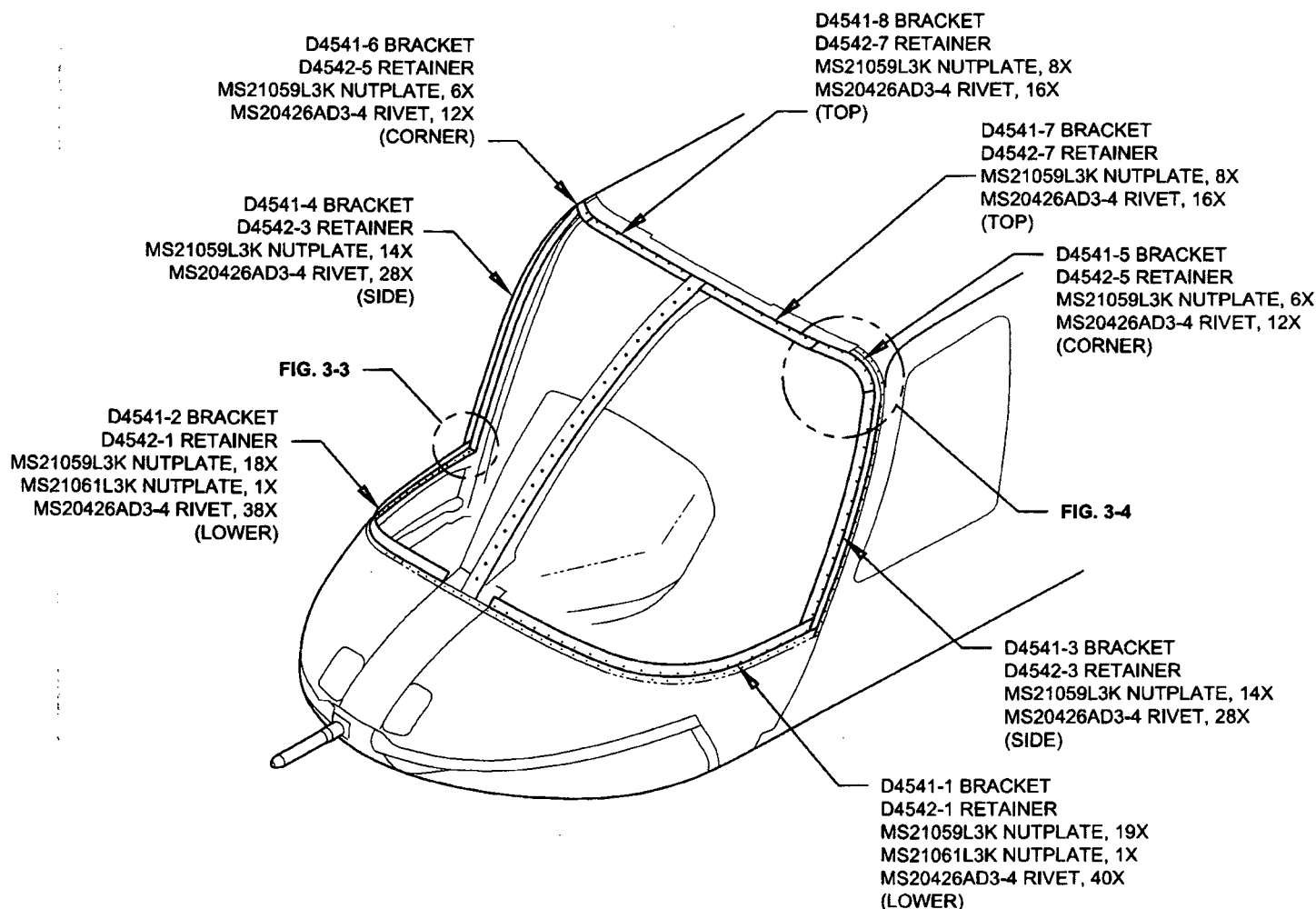


FIGURE 3-2
(REF IIN-D206-817 REV D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER KIT	NTS
DATE	14.03.18	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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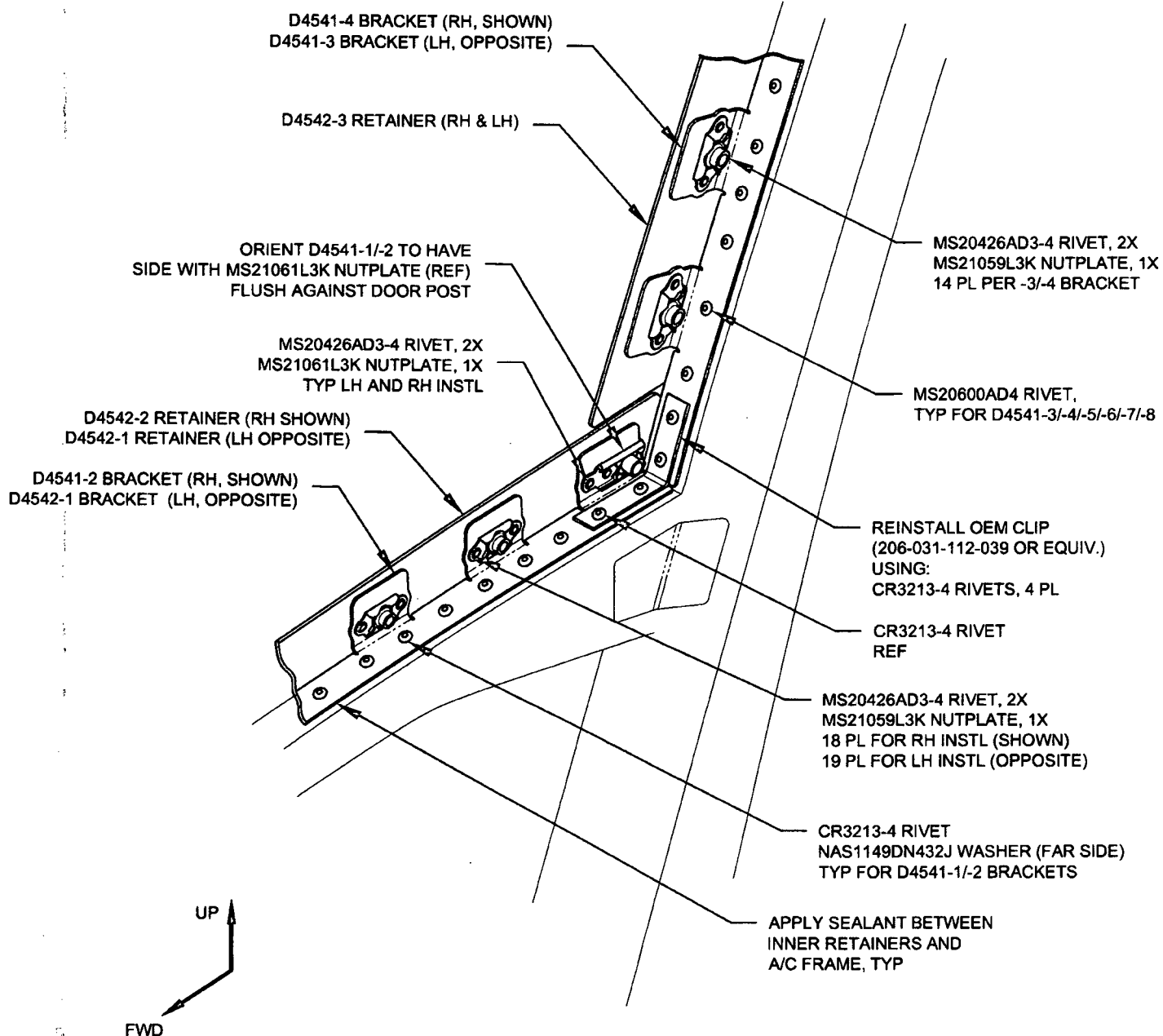


FIGURE 3-3
(REF IIN-D206-817 REV D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER KIT	NTS
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4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-3	BRACKET, LH
1	D4541-4	BRACKET, RH
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
1	D4541-7	BRACKET, LH
1	D4541-8	BRACKET, RH
2	D4542-3	RETAINER, INNER
2	D4542-5	RETAINER, INNER
2	D4542-7	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4543-5	RETAINER, LH OUTER (SIDE)
1	D4543-6	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
10	MS21061L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)

DART SERVICE INSTRUCTION

REFERENCE ONLY

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2
REF. TCCA STC SH12-3
REF. FAA STC SR03091NY
REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	AJS	14.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION
REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 13.06.20
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	<u>OS</u>	13.06.20
REV.	DESCRIPTION		BY DATE
DESIGN	<u>OS</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>OS</u>		
CHECKED	<u>140</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	<u>OS</u>	TITLE	SCALE
DE APPR.	<u>OS</u>	SEALANT TAPE	NTS
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